

Shp Jan 17

Work Order ID 95526

95526

Page 1

January-10-13 3:10:09 PM

Item ID: D3957-4 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hinge, Door RH Lower
 Start Date: 1/10/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 1/16/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3957	A

100

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

cut blank to 3.200" long

0.00

inf 13/01/11

4

0

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine as per Folio FA839

FOLIO REV: AA

DWG REV: A

0.00

B.a 13/01/13

4

0

DAS
08
2-83

2-FINISH TAPPING TO FULL DEPTH BY HAND AS PER DWG

3-DEBURR AS PER dWG

January-10-13 3:10:09 PM

Item ID: D3957-4

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Hinge, Door RH Lower

Stop *NS2*

Start Date: 1/10/13 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 1/16/13 **Req'd Qty:** 4.00 *** / ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

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Page 3

January-10-13 3:10:09 PM

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss (Ref 4.3.5.1) per OS100543-Alum <i>MID3383 11:45 320°</i> Memo MASK THREADED HOLE	0.00 0.00				<i>14</i>	<i>0</i>	<i>13-1-15</i>	
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>4</i>	<i>x</i>	<i>13/01/15</i>	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST079</i> Memo	0.00 0.00				<i>4x</i>		<i>SP</i> <i>13-01-16</i>	

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Page 4

January-10-13 3:10:09 PM

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 13-01-16
 MF
 13-1-16

Picklist Print

January-10-13 3:10:08 PM

Page 1

Work Order ID: 95526

Parent Item: D3957-4

Parent Item Name: Hinge, Door RH Lower

Start Date: 1/10/13

Required Date: 1/16/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X03.000 6061-T6 Bar .750 x 3.00		Purchased	No			100	f	20.5780	0.266	1.12			

Location

Loc Qty

Loc Code

MAT049

20.578

104741

20.494

15211

0.084

1.12

OK 1/13/01/11

DART AEROSPACE LTD		Work Order: 95526
Description: Hinge, Door RH Lower		Part Number: D3957-4
Inspection Dwg: D3957	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

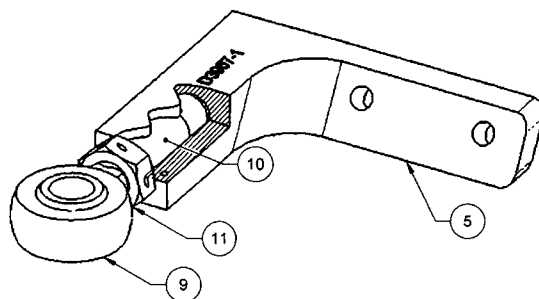
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.69	+/-0.030	0.684	✓		Vern	GA-01
0.281	+/-0.010	0.277	✓		"	"
0.281	+/-0.010	0.281	✓		"	"
3.00	+/-0.030	3.000	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-G	ref.
0.563	+/-0.010	0.562	✓		Vern	GA-01
1.25	+/-0.030	1.260	✓		"	"
1.93	+/-0.030	1.944	✓		"	"
107°	+/-0.5°	107°	✓		Angle Meter	CNC-03
0.250	+/-0.010	0.255	✓		Vern	GA-01
Ø0.203	+0.005/-0.001	Ø0.204	✓		"	"
1.170	+/-0.010	1.170	✓		"	"
0.39	+/-0.030	0.378	✓		"	"
0.33	+/-0.030	0.332	✓		H-G	31006
Ø0.063	+0.004/-0.001	Ø0.065	✓		Vern	GA-01
0.125	+/-0.010	0.128	✓		H-G	31006
0.094	+/-0.010	0.094	✓		"	"
0.12	+/-0.030	0.150	✓		Vern	GA-01
R0.50	+/-0.030	R0.500	✓		R-G	ref.

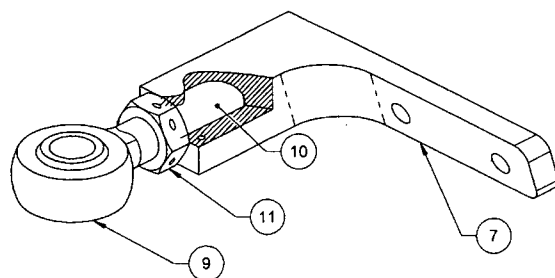
Measured by: D.A. 08	Audited by: 04	Prototype Approval:	N/A
Date: 13/01/13	Date: 12.1.14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.12.14	New Issue	KJ	

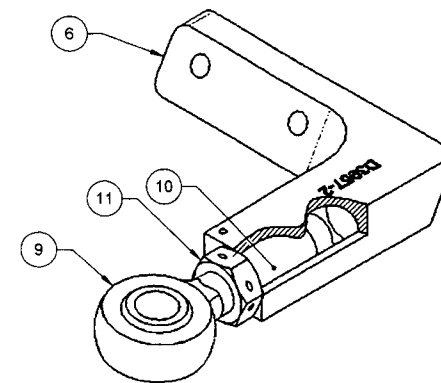
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



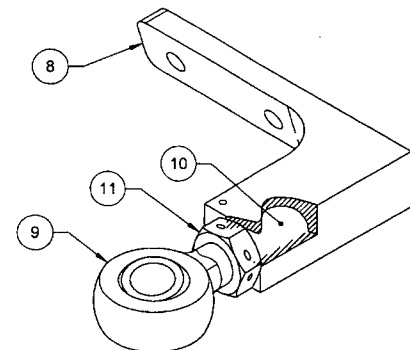
D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



D3957-042 HINGE ASSY, DOOR RH UPPER



D3957-044 HINGE ASSY, DOOR RH LOWER

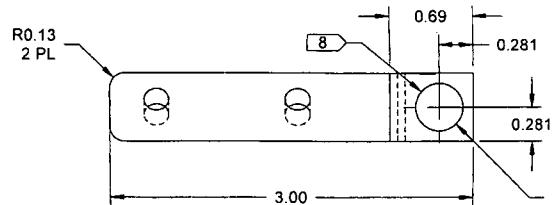
RELEASED
2009-10-03
W

95526

A	NEW ISSUE	BY	09.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.09.03	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

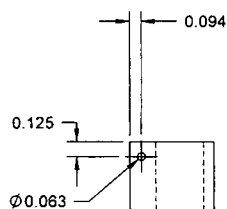
8 7 6 5 4 3 2 1

D



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE

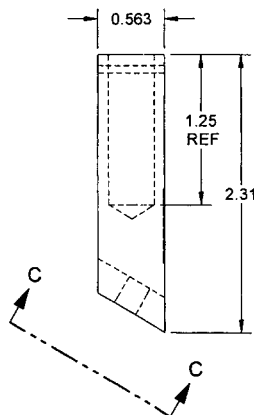
C



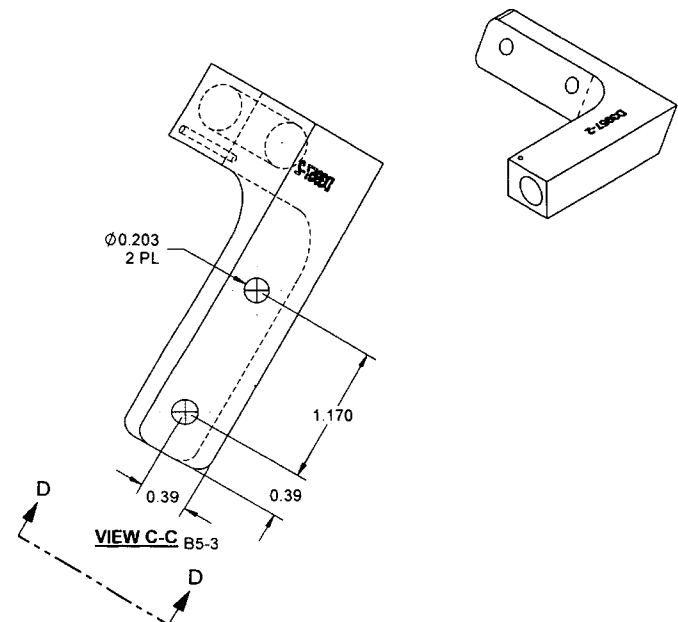
6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 ± 0.005



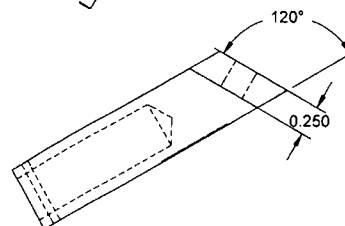
B



D3957-2 HINGE, DOOR RH UPPER



VIEW C-C B5-3



VIEW D-D

C3-3

RELEASED
 2009-10-08

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

A

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 3 OF 5
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DE APPR.		HINGE	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

R0.13
2 PL

8

0.69

0.281

0.281

3.00

DRILL AND TAP FOR 3/8-24 HELICAL INSERT
Ø0.391 X 1.25 DP
INSTALL HELICOIL MS124818
FLUSH WITH SURFACE

0.125

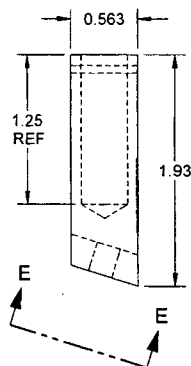
0.094

Ø0.063

6 ENGRAVE P/N TO DEPTH OF 0.005
IN THIS LOCATION WITH TOOL
TIP RAD OF 0.015 ±0.005

0.12

R0.50



Ø0.203
2 PL

1.170

F 0.33

0.39

VIEW E-E B5-4 F

107°

0.250

VIEW F-F C3-4

D3957-3 HINGE, DOOR LH LOWER

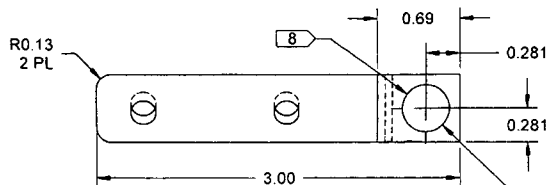
RELEASED
2009-10-08
map

NOTES:

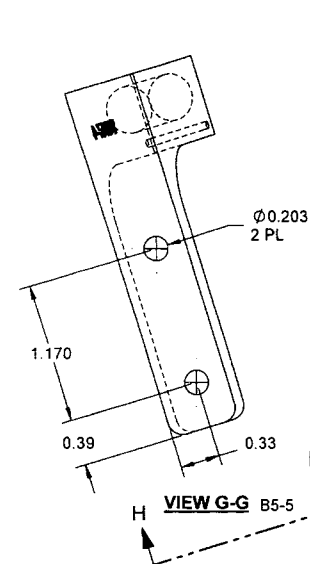
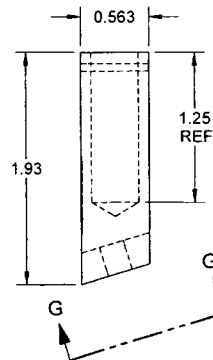
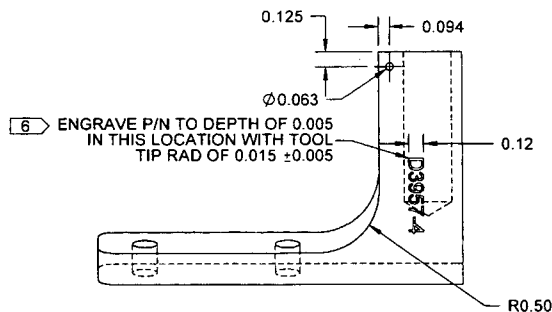
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
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PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
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POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	DE	DART AEROSPACE LTD	
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CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3957	SHEET 4 OF 5
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8 7 6 5 4 3 2 1



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



VIEW H-H C3-5

D3957-4 HINGE, DOOR RH LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
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RELEASED
 2009-10-08

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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